Work Order ID 94481 Page 1 December-19-12 11:19:20 AM Item ID: D4016-1 Accept *N900040100* Setup Start Revision ID: Item Name: Hinge Half, Base Start Date: 12/25/12 **Start Oty: 24.00 Cust Item ID:** Required Date: 1/18/13 Reg'd Oty: 24.00 **Customer:** Reference: Run Date: \2-\2-\9 Tooling: Approvals: Process Plan: __MLS Date: Stop Date: _____ **SPC (Y/N):** ... Date: -200 Operation Description Reject Sequence ID/ Set Up/ 3 Tool ID Tool # Plan Accept Reject Insp. Work Center ID **Run Hours** Code Otv Otv Number Stamp **Draw Nbr Revision Nbr** D4016 Α 100 Cut blanks as per folio 0.00 *100* 0.00 Bandsaw Memo Jeaspa Bandsaw CUT BLANK 1.00" LONG 0.00 110 *110* HAAS 1 0.00 Memo HAAS CNC vertical machine #1 MACHINE AS PER FOLIO FA869 AND DWG

DEBURR

DWG REV: 7

OFC/ba 2013-01-12

	6	
NCR:	(Yes	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:	2013/201	1
Closed: C Pate:	1/23	

Work Orde	ır.	944	81		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part N	Part No. <u>D4016-1</u> NCR No. <u>13-2225</u>				Rework Scrap V Use-as-is Work Order Update Skid-tube Machining Machining Thermoforming Finishing Large Fab Composite		ł	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other			
Root				Descri	ption of work order update	lr	nitial	Act	ion	Sign &		
Cause	Da	te Ster	Qty		or Non-conformance	Chi	ef Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	13/11	t 100	X	1 PAA Sour Fi to 0.86	has a taper in ill rom o. 875 at Botton il his top.	QZ	AS 16, 2042 1/15	SURAP + DE		B-01-15	13 lelis	1545 155) 052042 13/114
					F,	AULI	CATE	GORY				
Landir	ng Gear				General	_				-		
	Crac Crus Cuff Heat Insp	e Not Cond s ied/Crimpe	d. in Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/Uenance eled	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/ Openates C	oct ssing Vrong Surge	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Turning Sequence				Finish	\vdash		Sequence		Gioris NC	- KUK	
	_	e/Twist in T			Folio			e Dimensions				

											DQA:	Date.	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORI\	ANCE / UP	DATE			
									· · · · · · · · · · · · · · · · · · ·		QA Closed:	Date	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIN OIG	•					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part I	No.					Scrap		ı	Machining	Small Fab	4	od. Eng. Coor.	Quality
NCR I	No.					Use-as-is Work Order Update	_		noforming Large Fab	Finishing Composite	, Rec/Sto	re/Packaging Supplier	Other
Root		•		T	Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material	П												
Setup	П												
Other	П												
Process	П		ş-	.	•		-						
Supplier						•							
Training	П												
Unapproved							1						
٠.	÷					F	AUI	LT CATE	GORY				
Landi	ing C	iear				General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to O	/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ect	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/N	lissing	Wrong Stock Pulled
	\vdash	Cuffs				Contamination		Mainte	enance	-	Part Moved	1	-
		Heat Trea	at			Countersink		Mislabe	led		Positioned	Wrong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misreac	i		Power Loss	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Set Up/

Description Run Hours Code Qty Qty Number Stamp

QC21- Final Inspection - Work Order Release 0.00

Memo 0.00

Tool ID

Tool # Plan

Quality Control

170

Sequence ID/

170

OC

Work Center ID

Operation

WB01/6

Reject

Accept

Reject

Insp.

Page 3

										DQA:	Date:	
NCR: Y	'es / No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE		OA Classida	Data	
,		-			T					QA Closed:	Date	
					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	
Work Orde	er:	-			Davisel	٦		Skid-tube Crosstube	\Box	1	Water Jet	Engineering
Dowt N	la.				Rework	-		Skid-tube Crosstube Machining Small Fab	_	Dro	d. Eng. Coor.	Quality
Part N	NO				Scrap Use-as-is	┤		noforming Finishing	\vdash	4	e/Packaging	Other
NCR N	do.				Work Order Update	-		Large Fab Composite	·	1 1180/3101	Supplier	-
NCK	.			· · · · · · · · · · · · · · · · · · ·	Work order opdate	J		composite	<u> </u>	J	34ppe. [لــا لـ
Root				Descri	ption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Cr	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material		1										
Setup						1						
Other												
Process												
Supplier						1						
Training												
Unapproved		<u> </u>										
	,			**		AUI	T CATE	GORY		<u> </u>		
Landir	ng Gear			Г	General	_	1		_	٦	٣-	٦
	Bending			<u> </u>	Bend	\vdash	Grain		\vdash	Ovalized	⊢	Pressure/Forced
	Centre N	ot Conce	ntric to C	^{D/S} -	BOM/Route	\vdash	Hardwa		\vdash	Over/Under	}	Temperature/Cure
	Cracks			-	Broken/Damaged	_	4 `	ion Incomplete	\vdash	Part incorre	 	Weld
	Crushed	'Crimped	-		Burrs	\vdash	4	tions Incomplete/Unclear	-	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	\vdash	Mainte		-	Part Moved	Maria -	
1	Heat Tre	at]	Countersink		Mislabe	eled		Positioned V	vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

December-19-12 11:19:20 AM

Work Order ID: Parent Item:

94481

D4016-1

Parent Item Name:

Hinge Half, Base

Start Date: 12/25/12

Required Date: 1/18/13

Page 1

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD

IPP Rev:B as per dwg REV.A DD

10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	10.9800	0.08	1.92	-		,; H.,
304 bar 1.00 x 1.00										ET 12	5-01	-(0	
				Location		Loc Qty	<u>Lo</u>	c Code		_			
				MAT049		10.98							

122008

10.98

X1.92

											DQA:	Date:	:
NCR: Y	Yes /	No				WORK ORDER NON-C	OI	NFORN	MANCE / UPDA		QA Closed:	Date	
	<u>.</u>					DISPOSITION			· · · · · · · · · · · · · · · · · · ·	AGAINST DE			•
Work Orde	er:						,					_	-
Part N	No					Rework Scrap Use-as-is		Therm	Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	Vo					Work Order Update]		Large Fab (Composite		Supplier	
Root					Descri	ption of work order update		nitial	Action	n .	Sign &		
Cause	[Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data	Ш						ļ	,			1		
Equip/Tooling		1											
Operator		1											
Material							1	ļ			!		
Setup													•
Other		İ											
Process													
Supplier													
Training							1						
Unapproved	П												
						F	AUL	T CATE	GORY				
Landi	ng Gea	r				General		•					
	Be	nding				Bend		Grain			Ovalized		Pressure/Forced
	Ce	ntre No	t Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cra	icks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Cru	ushed/C	rimped.			Burrs		Instruct	ions Incomplete/Un	clear	Part Lost/M	issing	Wrong Stock Pulled
	Cu					Contamination		Mainte	nance		Part Moved		
	He	at Treat	t			Countersink		Mislabe			Positioned \	V rong	
İ	Ins	pection	Strip in	Tube		Cut Too Short		Misreac	I		Power Loss/	_	Other
		nles in	•			Drill Holes		Offset				- <u>_</u>	

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	94481
Description: Hinge Half, Base	Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	,877			ven	BT-4
0.25	+/-0.030	, 244			,	
0.38	+0.030/-0.000	, 790				
R0.03	+/-0.030	.070				
0.13	+/-0.030	.123				
0.88	+/-0.030	.877				
Ø0.257	+0.006/-0.001	.257	~			
R0.38	+/-0.030	,375				•
0.500	+/-0.030	.50(/			
0.75	+/-0.030	.753				

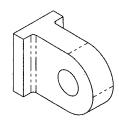
						•

Measured by:	Audited by: 32	Preliminary Approval:
Date: 13-01-11	Date: 13-01.14	Date:

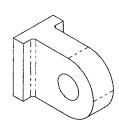
Rev	Date	Change	Revised by	Approved
Α	10.06.07	New Issue	KJ 💠	

D

D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



SHOPCHAY RETURNETH, ENGINEER, NO. UNCONTROLLED ... SUBJECT TO AMEND "IN WITHOUT OF A WORK ORDER NO. 94481 MCS

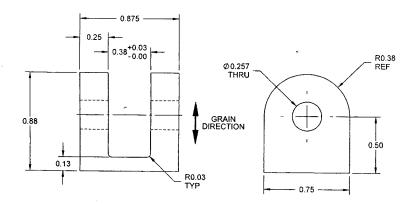
D4016-5 HINGE HALF, LIGHT LID

RELEASED 2010 -02- 16

Α	NEW ISS	il F		JPH	10.01.29					
REV.	11211100		BY	DATE						
DESIG	٧.	AJS	DART AERO	DART AEROSPACE LTD						
DRAW	٧	AJS	HAWKESBURY, ON		-					
CHECK	ŒD	a	DRAWING NO.		REV. A SHEET 1 OF 2					
MFG. A	PPR.	7	D4016							
APPRO	VED	140.	TITLE		SCALE					
DE APP	PR.	_#	BASKET HINGE		NTS					
DATE	10.0	1.29	COPYRIGHT © 2010 BY THIS DOCUMENT IS PRIVATE AND COMPRESSION INC. NOT TO BE USED FOR ANY PURPOSE OF COMPLESSION FROM WRITTEN PERMISSION FROM WRITTEN PERMISSION FROM	S CUPPLIED ON THE EXPRES CONMUNICATED TO ANY OT	S CONDITION THAT IT IS					

D

С



D4016-1 HINGE HALF, BASE

D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LIGHT LID

GRAIN DIRECTION

R0.03

--- 0.563 --

0.50

- 0.13

0.63

0.13

0.250

R0.31

REF

Ø0.257 THRU

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	NZ.	D4016	SHEET 2 OF
APPROVED	140	TITLE	SCALE
DE APPR.	-#	BASKET HINGE	NTS
DATE 10.01.29		COPYRIGHT © 2010 BY DARY AEROSPACE LYD THIS COCUMENT IS PRIVATE AND CONFEDENTIAL AND IS SUPPLIED ON THE EAPPLESS CONDITION THAT IT IS	

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

Α

С

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 bs
-3: 0.04 lbs
-5: 0.01 lbs